

Work Order ID 58273

May 3, 2010 9:53:04 AM



Page 1

Item ID:	D2991-2	Accept		Setup	Start	
Revision ID:						
Item Name:	Side Door				Stop	
Start Date:	03/05/2010	Start Qty: 1.00		Cust Item ID:		
Required Date:	13/05/2010	Req'd Qty: 1.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>PL</u>	Date:	<u>10-5-03</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2991	D								

110		0.00							
	Purchasing								<u>PL 10-5-03</u>
Purchasing		0.00							
Purchasing	Memo Issue P/O: <u>11809</u> Description: D2991-2 side door Supplier: Delastek Ship to delastek: Qty 2 D2992-1 Doubler batch: <u>47743</u> Certificate of Conformity and process sheet from Delastek								
120		0.00							
	Receive & Inspect for Damage & Mat'l Certs								<u>PL 10-5-03</u>
Packaging		0.00							
Packaging	Memo Ensure certificate of conformity is attached								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58273

May 3, 2010 9:53:04 AM



Page 2

Item ID: D2991-2

Accept



Setup Start



Revision ID:

Item Name: Side Door

Stop



Start Date: 03/05/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D2991

8/06/08

40

140

Identify as per dwg & Stock Location: composites

0.00



Packaging

Memo

0.00

Packaging

10-26-08

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/08

pl 10-6-08

①

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

May 3, 2010 9:53:10 AM

Page 1

Work Order ID: 58273

Parent Item: D2991-2

Parent Item Name: Side Door


Comments: IPP rev. A 06.02.16 new issue (was done on D350-589-041) EC
IPP Rev:B 08-02-20 ECN 1096 DD verified by:EC

Start Date: 03/05/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2991-2P		Purchased	No			110	Each	1.0000	1			
												
SIDE DOOR												

Location

Loc Qty

Loc Code

CA

1

56811

1



Rec'd 5/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

D2991-1/-2/-3 SIDE DOOR

NOTES

- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS: RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8" A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR HYSOL 956A/B MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR METALSET A4, OR MAGNABOND 6398. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: NONE
- 13) WEIGHT: 9 lbs TYP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58223
300503

RELEASED
2009-10-30

D	REFORMAT DWG, ADD DIMS TO DOUBLERS (ZN D7-2, D3-3, D7-4), X.X TOL WAS X.XX (ZN D7-2, D3-3, D7-4, A8-5, A4-5), D2992-1 NOW 4.000 WIDE (ZN D7-2, D5-3, D4-4), RMV DECAL (ZN A8-1), NCR 09-041	CP	09.09.26
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.09.26		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2991	REV. D SHEET 1 OF 5
TITLE SIDE DOOR	SCALE NTS
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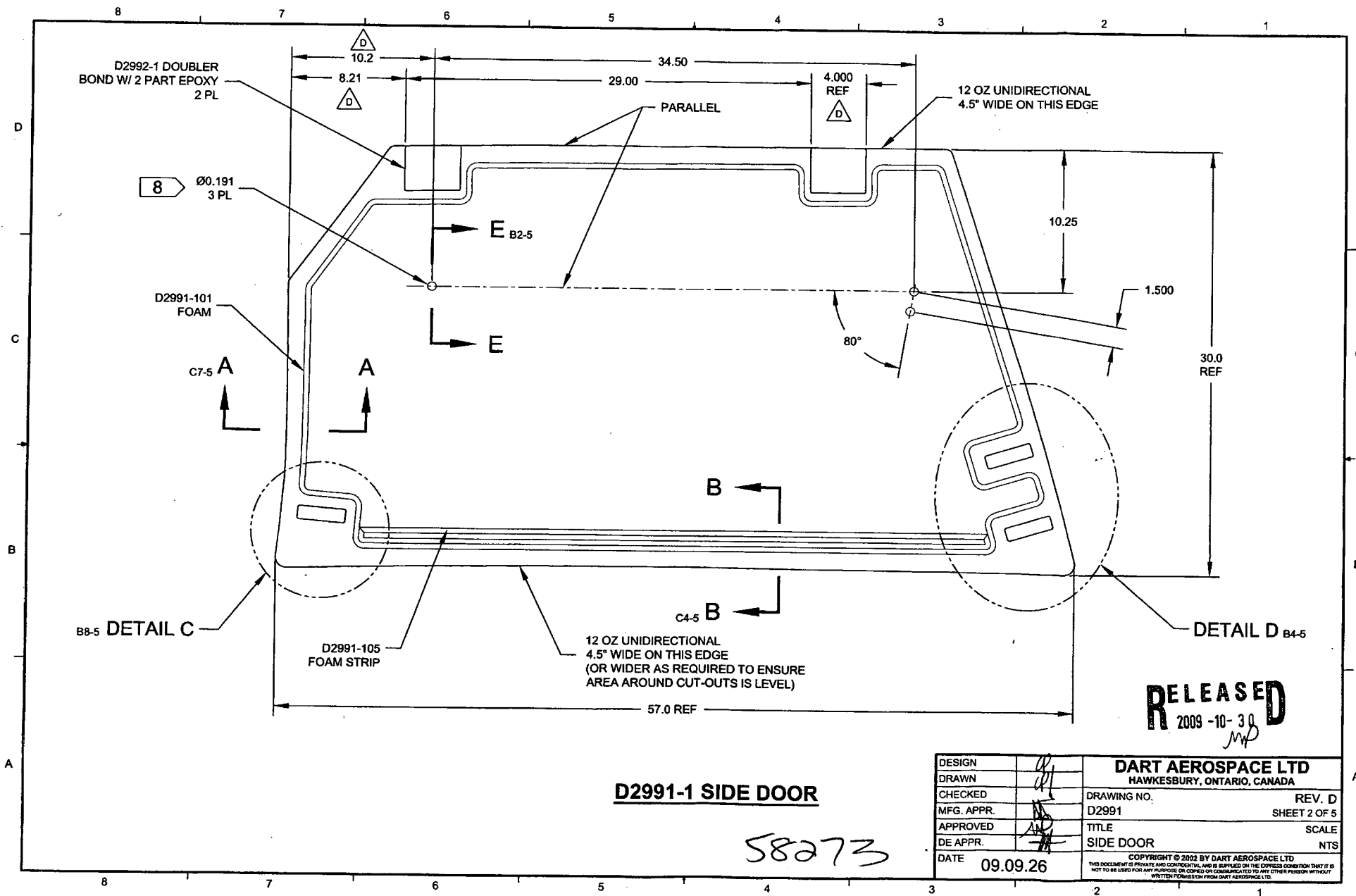
W/O:		WORK ORDER CHANGES					
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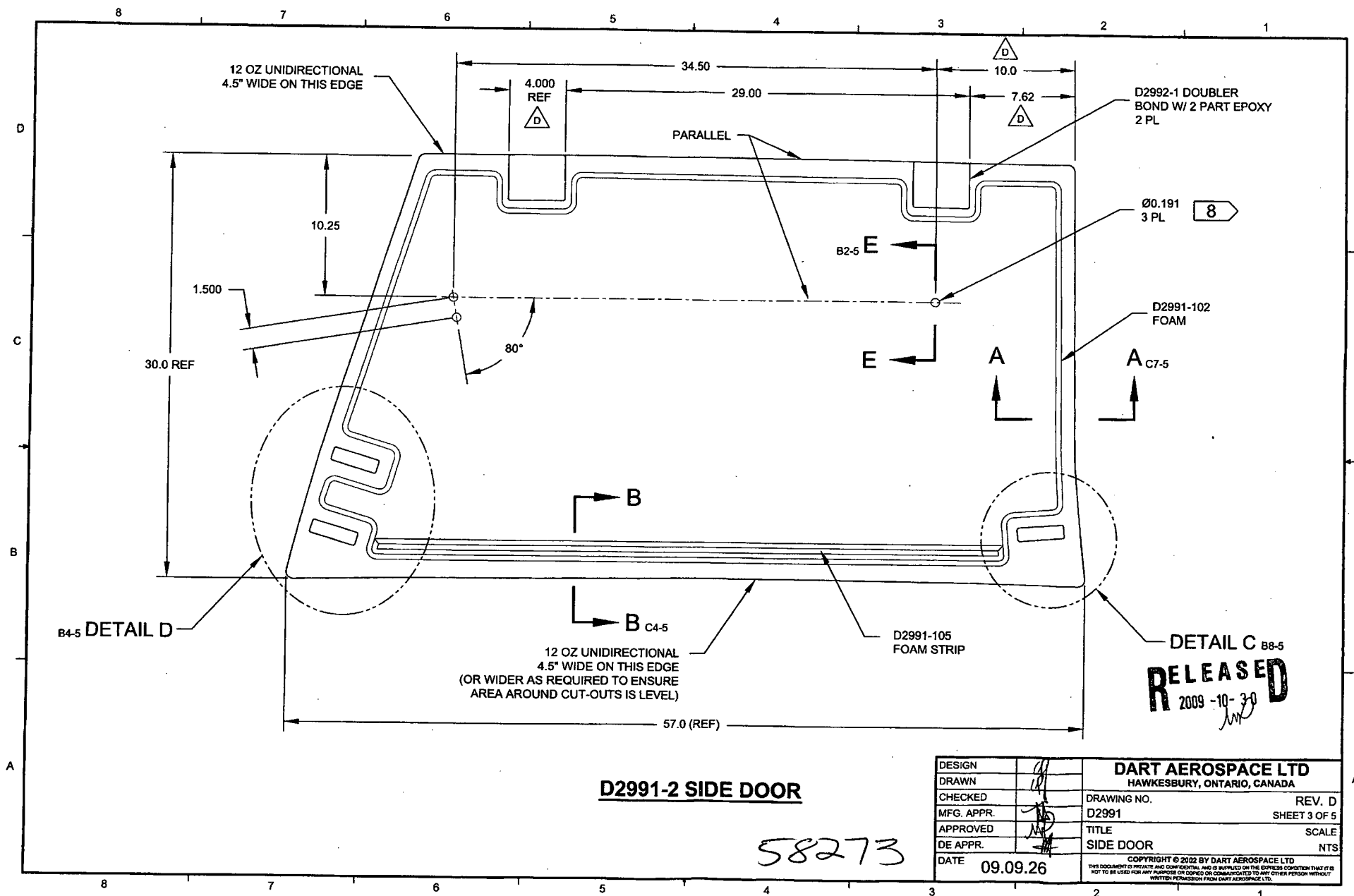
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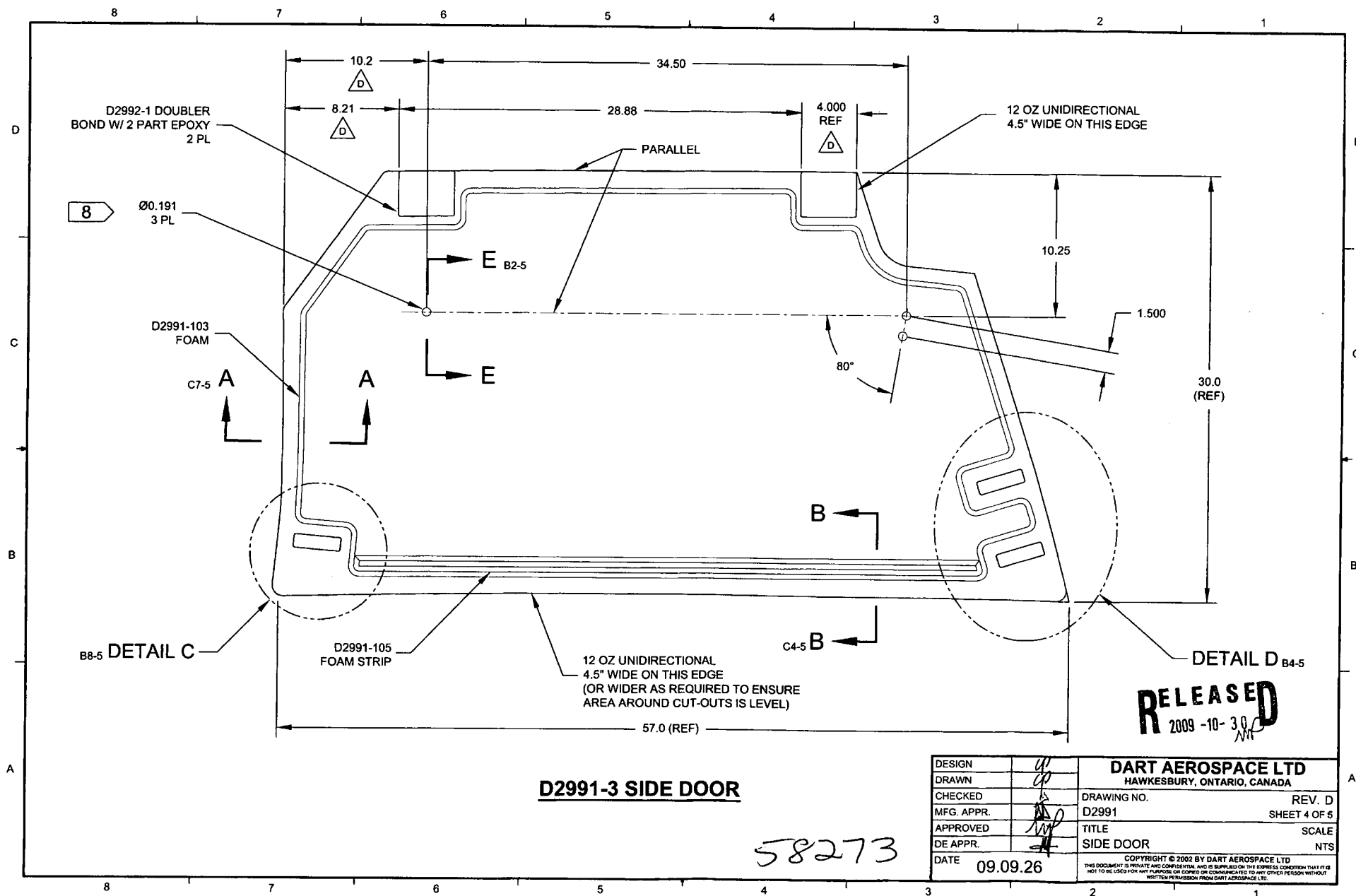
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DESIGN	up	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	up		
CHECKED	up	DRAWING NO.	REV. D
MFG. APPR.	up	D2991	SHEET 4 OF 6
APPROVED	up	TITLE	SCALE
DE APPR.	up	SIDE DOOR	NTS
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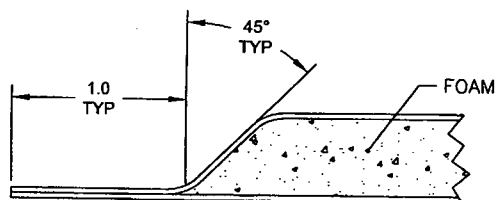
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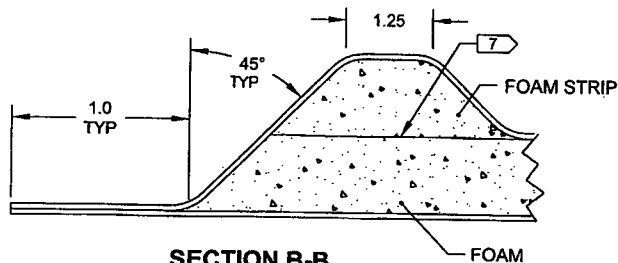
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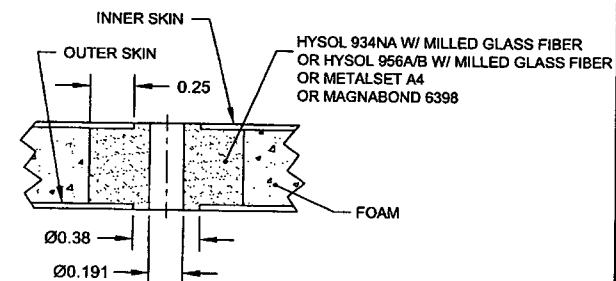
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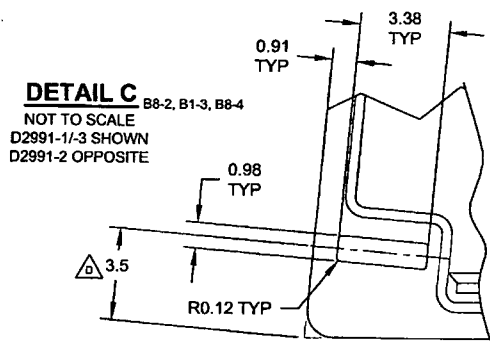
SECTION A-A
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE
C7-2, C2-3, C7-4



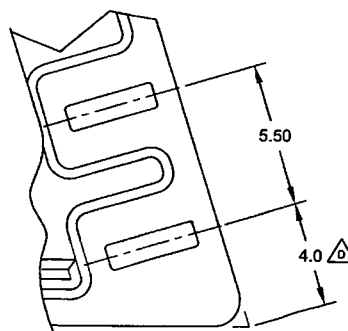
SECTION B-B
ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/-3 SHOWN
D2991-2 OPPOSITE
B4-2, B5-3, B4-4



SECTION E-E
TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE
D6-2, D3-3, C6-4



DETAIL C
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE
B8-2, B1-3, B8-4



DETAIL D
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE
B1-2, B8-3, B1-4

RELEASED
2009-10-30

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2991	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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58273

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO11819

Purchase Order Date 04/05/2010

PO Print Date 04/05/2010

Page Number 1 of 1

Order From :

VU-DEL003

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 123

GRAND-MERE, QC G9T 5K7
CA

Contact Name
Vendor Phone 819 533 5788
Vendor Fax 819 533 3494
Vendor Account Nbr

Buyer Brigitte Golden
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency USD
FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2991-2P	SIDE DOOR	07/06/2010 Yes	1.00 Each	Purolator ground	\$820.0000	\$820.00
Special Inst:			DWG: D2991, REV: D B# 58273 DKC134-0067				
2	D2991-1P	SIDE DOOR	07/06/2010 Yes	1.00 Each	Purolator ground	\$820.0000	\$820.00
Special Inst:			DWG: D2991, REV: D B# 58272 DKC134-0066				

PO Total:

\$1,640.00

Change Nbr: 1

Change Date: 04/05/2010

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère; Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	33348
Customer #	DART US

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

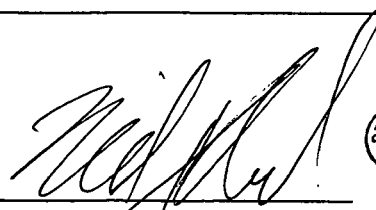
DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
04/06/2010	03/05/2010	14003	Brigitte Golden		PO11809		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0067	Line 1 Side Door N° D2991-2 SN: B# 58273 Dwg.: D2991 Rév.: D			
				No. lot 26264			
				U de M : Each Qté 1			
				8/10/06/06			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:


Quality department AQ-357



☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date : Mercredi, 2010-05-05 10:20:02
U. sahur : marc dubé

Feuille de Procédé

Client : DART US DART AEROSPACE LTD

Numéro Job : 26264

Numéro Soumission : 3761

Numéro B.A. :

Cette fois : 2010-05-05 No. B.V. :

Prsht Rev. : NC

Prem. fois : - - Type :

Job précédente : 24883

Écrit par : _____

Vérifié & Approuvé par : _____

Commentaires : N. de pièce client: D2991-2

Nom Dessin : SIDE DOOR N. D2991-2

Numéro Article : DKC134-0067

Numéro Dessin : D2991

Projet Numéro : DK-134

Révision dessin : D

Matériel : Composites

Date Due : 2010-05-12

Qté: 1 Udm: UNITE

Inscrire le N° de
Série : B58273 Sur la
pièceProcess Sheet Rév.: 00 Création du premier dans DKA à partir de la
Rév.: 00 De DKC

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AAC0854 Frekote #700-NC

Commentair Qty.: 0.025 UNITE(s)/Unit Total : 0.025 UNITE(s)

2.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule N° DKO-0095 selon IG0019 (réf. IG 0009).

Date: _____ Sceau: _____

3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

1-27406-1

Commentair Qty.: 0.040 UNITE(s)/Unit Total : 0.040 UNITE(s)

4.0 AMB0286 Catalyst N° DDM-9

1-22176-1

Commentair Qty.: 0.0040 GALLON(s)/Unit Total : 0.0040 GALLON(s)

5.0 AAC1606 UN2055 styrene monomere ST

Commentair Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s)

6.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire la préparation et l'application du Gel Coat selon IG0019, diluer à l'aide de 10% de UN2055 styrene monomere ST

Date: 11-5-10 Sceau: 34 Temps Début: _____ Temps Fin: _____



Date: Mercredi, 2010-05-05 10:20:02
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 26264

Nom Dessin: SIDE DOOR N. D2991-2
Numéro Article: DKC134-0067

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

7.0	AC0883	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s)		
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8.0	AC0884	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)		
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9.0	AC0885	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)		
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10.0	AC0943	Stretchlon 200 poche à vide Vert
------	--------	----------------------------------

Commentair Qty.: 18.00 PIED(s)/Unit Total : 18.00 PIED(s)		
---	--	--

11.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
------	---------	---

Commentair Qty.: 7.3 VERGE(s)/Unit Total : 7.3 VERGE(s)		
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12.0	AMB0349	Fiberglass 12 oz Unidirectional
------	---------	---------------------------------

Commentair Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s)		
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13.0	AC0886	Ruban à gommer jaune #: T/IAT-200Y
------	--------	------------------------------------

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)		
---	--	--

14.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 4-9-09 Sceau:



15.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentair Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s)		
---	--	--

16.0	AMB0286	Catalyst N° DDM-9
------	---------	-------------------

Commentair Qty.: 0.0020 GALLON(s)/Unit Total : 0.0020 GALLON(s)		
---	--	--

Date: Mercredi, 2010-05-05 10:20:02
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 26264

Nom Dessin: SIDE DOOR N. D2991-2
Numéro Article: DKC134-0067

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

17.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 11-5-10 Heure Début: Heure Fin: Sceau:  

18.0	LAMINAGE	Faire le laminage
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DKO-0095 et ensuite imbiber un pli de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 11-5-10 Heure Début: Heure Fin: Sceau:  

19.0	BAGGING	Faire le bagging sur la pièce
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Installer la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Date: 11-5-10 Sceau:  

Curing début: 1:50 Curing Fin: 8:00

20.0	AAC1611	Polybond B46F
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Commentair Qty.: 0.143 KIT(s)/Unit Total : 0.143 KIT(s)

21.0	DKC134-0063	Foam Core N° D2991-102(Porte D2991-2)
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26402

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

22.0	ASSEMBLAGE	Assemblage mécanique
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Retirez le bagging.

Installer le Foam Core D2991-102 selon IG 0033

Date: Mercredi, 2010-05-05 10:20:02
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 26264

Nom Dessin: SIDE DOOR N. D2991-2
Numéro Article: DKC134-0067

Numéro Job:



Séq.: Machine ou Opération:

Description

Date: 31-5-10 Heure Début: — Heure Fin: — Sceau: 34 65

23.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 2 heures minimum.

Date: 31-5-10 Sceau: 34 65

Curing Début: 8:25 Curing Fin: 9:35

24.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

1-27457-1

Commentair Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s)

25.0

AMB0286

Catalyst N° DDM-9

1-22176-1

Commentair Qty.: 0.0020 GALLON(s)/Unit Total : 0.0020 GALLON(s)

26.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 31-5-10 Heure Début: — Heure Fin: — Sceau: 34 65

27.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 31-5-10 Heure Début: — Heure Fin: — Sceau: 34 65

Date: Mercredi, 2010-05-05 10:20:02
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 26264

Nom Dessin: SIDE DOOR N. D2991-2
Numéro Article: DKC134-0067

Numéro Job:



Séq.: Machine ou Opération: Description :

28.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Date: 31-5-10 Heure Début: Heure Fin: Sceau:  


Curing Début: 1:05 Curing Fin: 8:00

29.0 DÉMOULAGE. Démoulage



Commentair Setup: 0.00Hrs/ Run: 5.0000Hrs Total Run : 5.0000Hrs

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ". Selon l'instruction générale de fabrication N° IG 0018

Date: 1-6-10 Sceau:  

30.0 TRIMAGE Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

À l'aide du gabarit N° DKO-0119 trimmer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2991.

Date: 1-6-10 Sceau:  

31.0 AAC0205 COLLE HYSOL EA934NA

1-26267-1

Commentair Qty.: 0.15 KIT(s)/Unit Total : 0.15 KIT(s)

32.0 AAC1540 Fibre de verre Miapoxy 66

1-7076-1

Commentair Qty.: 0.0037 GALLON(s)/Unit Total : 0.0037 GALLON(s)

33.0 TRIMAGE Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du Gabarit N° DKO-0119 Percer les 3 trous de 3/8" Dia.

À l'aide d'une clé Allen et en faisant bien attention de ne pas abimer les Skins de la pièce, venir faire un dégagement de 7/8" Dia dans le Foam Core entre les Skin intérieur et extérieur.

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 26264

Nom Dessin: SIDE DOOR N. D2991-2
Numéro Article: DKC134-0067

Numéro Job:



Séq.:

Machine ou Opération:

Description :

À l'aide de masking Tape, masquer le trou de la skin extérieur.

À l'aide d'un mélange 10:1 de résine Hysol EA934NA / Fibre courte Miapoxy 66 et d'une seringue, venir remplir les dégagements de 7/8" Dia préalablement fait dans le foam Core.

Laisser sécher.

Date: 1-6-10 Sceau:



34.0

TRIMAGE

Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N° DKC-0119 Repercer les 3 trous de 0.191" Dia.

Date: Sceau:

35.0

AAC0205

COLLE HYSOL EA934NA

1-26592-1

Commentair Qty.: 0.13 KIT(s)/Unit Total : 0.13 KIT(s)

36.0

AAC1681

N° D2991-2, Doubler

1-27426-1

Commentair Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)

37.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide de l'adhésif N° Hysol EA934NA, assembler le doubler N° D2992-1 sur la pièce de composite selon le dessin.

Date: 1-6-10 Sceau:



38.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.1800 UNITE(s)/Unit Total : 0.1800 UNITE(s) 1-26575-4

39.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.1800 UNITE(s)/Unit Total : 0.1800 UNITE(s) 1-26575-5

40.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PRIMER FINAL 03/06/10



Préparer et appliquer le primer selon I.G. 0008 et la fiche technique.

Date: 03/06/10 Sceau:



de Fiche Technique: N/A